

Thursday, 13/09/2007 8:37:29 AM

Linda Lacelle User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 34076B

Type

S.O. No. : NA

Estimate Number

: 10339

P.O. Number

: NIA

This Issue

: 13/09/2007/

Prsht Rev. First Issue

: NC

: 17/08/2007

: 33780B

Written By

Previous Run

Checked & Approved By

Comment

New Issue

05-11-07 Est Rev:B Now on Waterjet 06-08-23 JLM

: PURCHASED PARTS

Drawing Name

: LUG BRACKET

Part Number

Due Date

: D2658

Drawing Number

D2658 REV D

: N/A

Project Number **Drawing Revision** NA.

Material

: 20/09/2007

Qty:

30 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1010/1025/A21/6aA SHEET

1.0

M1010S12GA

Comment: Qty.: 0.1197 sf(s)/Unit Total: 3.5910 sf(s)

> 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK

Batch: M 104 388

2.0

Comment: FLOW WATER JET

1-Cut as per Dwg D2858 Dwg Rev: ______

Prog Rev:__

2-Deburr if necessary

3.0

QC2

BO7-09-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BRAKE NC 5.0

NC BRAKE



Comment: NC BRAKE

1-Debutt-as required.





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ندر :Date Thursday, 13/09/2007 8:37:29 AM User: Linda Lacelle **Process Sheet** Drawing Name: LUG BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 34076B Part Number: D2658 Job Number: Description: Seq. #: **Machine Or Operation:** 2-Bend on CNC brake using DT8254Identify as D2658 QC5 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 207/09/19 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

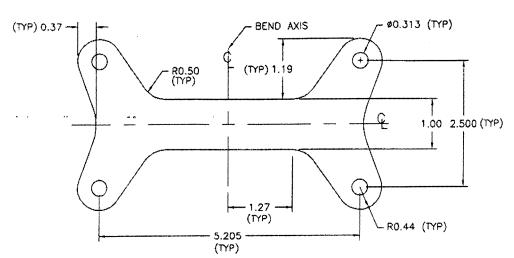


Wofe89.18

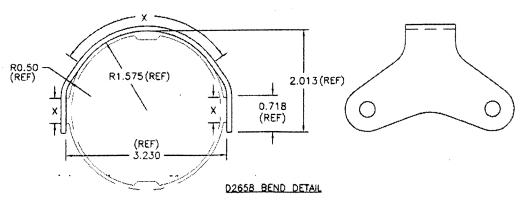


	DESIG	#	ORAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
Ì	CHEC	(ED_)	APPROYED	DRAWING NO, REV. D			
ı	(K –	KE	D2658 SHEET 1 OF 1			
ı	DATE		7	TITLE SCALE			
	98.1	2.14		LUG BRACKET . 5:9			
	Α		97.11.03	NEW ISSUE			
	В		97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE			
	С		98.10.23	UPDATE MATERIAL (TSR A1114)			
	ח		98 12 14	REMOVE TOOLING HOLE (TSR A1040)			





D2658 FLAT PATTERN SYMMETRICAL ABOUT BOTH CENTRE-LINES ($\mbox{\em C}\mbox{\em)}$



D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:
	340768
Description: Lub RRACKET	Part Number:
BOSCHES LAG BICKSON	D3658
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

•	" х	First Artic	ele _	Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejęct	Method of Inspection	Comments
1.00	4/030	1.00	*			•
2.500	+1010	J.200	*			
206.2	4/010	5.303	¥			
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Date:	67-09-17	Date: 6	Hos/17	ጾ	Da	te:
lev Da te	Change				Revi	sed by Approv
A	New Issue			······································	KJ/JL	

